

Select 81-Ni2

Description:

- A low alloy steel, flux cored, gas shielded electrode for welding in the flat and horizontal positions
- Intended for use with 100% CO₂ shielding gas
- Arc transfer is a smooth, small droplet spray
- The 2.5% nickel deposit is ideal for welding steels such as ASTM A203, A572, A575, and A734
- This electrode is well suited for offshore platform construction, mining machinery, and shipbuilding applications

Classification:

E80T1-Ni2C per AWS A5.29, ASME SFA 5.29
E80T1-C1A4-Ni2 per AWS A5.36, ASME SFA5.36

Typical Mechanical Properties:

	<u>100% CO₂</u>
Ultimate Tensile Strength (psi)	89,300
Yield Strength (psi)	76,500
Percent Elongation	27
CVN (ft-lbf) @-40°F	48

Typical Deposit Composition:

<u>Wt%</u>	<u>C</u>	<u>Mn</u>	<u>Si</u>	<u>P</u>	<u>S</u>	<u>Ni</u>
	.07	1.00	.29	.010	.010	2.23

Recommended Welding Parameters:

<u>Diameter</u>	<u>Optimum</u>			<u>Range</u>	
	<u>Amperage</u>	<u>WFS</u>	<u>Voltage</u>	<u>Amperage</u>	<u>Voltage</u>
1/16"	350	300	29	150-400	22-34
5/64"	390	250	29	280-430	26-33
3/32"	450	210	31	300-550	26-34

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Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. Select-Arc disclaims any warranty of merchantability for any particular purpose with respect to its products.